

Date: Thursday, 4/12/2007 8:20:44 AM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|--|---|---|----------------|--|-----------|------------------|
| Customer | CU-DAR001-Dart Helicopters Services | | Drawing Name | SADDLE FITTING, FWD (OUTBOARD/INBOARD) | | |
| Job Number | 31648 | | Part Number | D2572 | | |
| Estimate Number | 10531 | | Drawing Number | D2572 REV E | | |
| P.O. Number | N/A | | Project Number | N/A | | |
| This Issue | 4/12/2007 | S.O. No. | N/A | Drawing Revision | E | |
| Prsht Rev. | NC | Type | MACHINED PARTS | Material | N/A | |
| First Issue | N/A | | | Due Date | 4/19/2007 | Qty: 12 Um: Each |
| Previous Run | 31146 | | | | | |
| Written By | | | | | | |
| Checked & Approved By | <u>JF</u> 07.04.12 | | | | | |
| Comment | Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ | | | | | |
| Additional Product | | | | | | |
| Job Number: |  | | | | | |
| Seq. #: | Machine Or Operation: | Description : | | | | |
| 1.0 | D6101005 | 7075-T7351 8.25X5.0X2.5  | | | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B25350</u> <u>X12</u> | | | | | | |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1  | | | | |
| Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B31649</u> Double check by: <u>J.F.</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. | | | | | | |
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE  | | | | |
| Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 <u>Mr. FmL 07/05/22</u> <u>12</u> | | | | | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE  | | | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>Mr. FmL 07/05/22</u> <u>12</u> | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:20:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31648

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

21 07/05/27

12

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



PTC

13

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

28

0705.2812

14

7.0 POWDER COATING

POWDER COATING



15

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/05/29

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



16

Comment: INSPECT POWDER COAT

07/05/29(11)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



17

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/29(11)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(11)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/30

Job Completion



07.05.30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2572 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: ✓ Date: 07/05/30
 QA: N/C Closed: ✓ Date: 07/05/30

| WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|----------------------------------|------|--|-----------------------------|--|-----------------|-----------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | |
| 07/05/29 | 6.0 | 1 part scrap left in the acidetch tank for 24hrs. R.C. Employee did not check tank @ Qty. | <u>AS1042</u> | Yesterday. Ensure employee's check tanks @ Qty when chemical conversion coating. | <u>07/05/29</u> | <u>✓</u> <u>07/05/30</u> | <u>DB</u> <u>07/05/29</u> <u>07/05/29</u> |
| | | | | | | | |
| | | | | | | | |

NOTE: Date & initial all entries

| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 31648 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | .438 | .438 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.747 | 1.747 | 1.749 | 1.747 | | |
| C | 3.495 | 3.505 | | 3.499 | 3.501 | 3.499 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.747 | 1.747 | 1.748 | 1.747 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.002 | 8.003 | 8.003 | | |
| F | 0.490 | 0.510 | | 0.499 | 0.503 | 0.499 | 0.497 | | |
| G | 0.257 | 0.262 | DT8683 | .260 | .260 | 0.260 | 0.260 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.496 | 0.497 | 0.496 | 0.496 | | |
| J | 1.174 | 1.184 | | 1.176 | 1.175 | 1.175 | 1.176 | | |
| K | 0.558 | 0.578 | | 0.565 | 0.563 | 0.561 | 0.561 | | |
| L | 1.174 | 1.184 | | 1.176 | 1.175 | 1.175 | 1.176 | | |
| M | 1.490 | 1.500 | | 1.494 | 1.492 | 1.494 | 1.491 | | |
| N | 2.495 | 2.505 | | 2.496 | 2.496 | 2.498 | 2.496 | | |
| O | 3.869 | 3.879 | | 3.873 | 3.872 | 3.872 | 3.873 | | |
| P | 0.115 | 0.135 | | 0.127 | 0.126 | 0.127 | 0.126 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.252 | 0.251 | 0.252 | 0.253 | | |
| S | 0.115 | 0.135 | | 0.121 | 0.121 | 0.120 | 0.122 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.189 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.237 | 0.239 | 0.233 | 0.238 | | |
| W | 0.115 | 0.135 | | 0.125 | 0.125 | 0.122 | 0.120 | | |
| X | 0.307 | 0.312 | | 0.312 | 0.311 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.365 | 0.365 | 0.360 | 0.360 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.627 | 0.627 | 0.625 | 0.626 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | 0.249 | 0.246 | 0.246 | 0.246 | | |
| AE | 1.375 | 1.395 | | 1.387 | 1.389 | 1.389 | 1.387 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.131 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.247 | 0.246 | 0.244 | 0.247 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.000 | 2.000 | 2.000 | | |
| AJ | 0.023 | 0.043 | | .032 | .032 | .032 | .032 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|-----------------|-------------|-----------------|
| Measured by: | <i>MS/EP</i> | Audited by: | <i>SK</i> |
| Date: | <i>07/05/24</i> | Date: | <i>07/05/24</i> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|---------------------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | <i>JK</i> <i>SK</i> |

| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 31648 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|-----|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.748 | 1.746 | 1.747 | 1.749 | | |
| C | 3.495 | 3.505 | | 3.499 | 3.500 | 3.501 | 3.506 | | |
| D | 1.745 | 1.755 | | 1.748 | 1.746 | 1.747 | 1.749 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.002 | | |
| F | 0.490 | 0.510 | | 0.498 | 0.497 | 0.500 | 0.502 | | |
| G | 0.257 | 0.262 | DT8683 | 0.260 | 0.260 | 0.260 | 0.260 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.496 | 0.498 | 0.498 | 0.496 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.178 | 1.178 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.565 | 0.565 | 0.566 | 0.559 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.178 | 1.179 | 1.177 | | |
| M | 1.490 | 1.500 | | 1.492 | 1.494 | 1.494 | 1.493 | | |
| N | 2.495 | 2.505 | | 2.498 | 2.498 | 2.497 | 2.498 | | |
| O | 3.869 | 3.879 | | 3.873 | 3.871 | 3.872 | 3.870 | | |
| P | 0.115 | 0.135 | | 0.126 | 0.126 | 0.125 | 0.126 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.252 | 0.251 | 0.251 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.124 | 0.124 | 0.124 | 0.125 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.239 | 0.238 | 0.237 | 0.241 | | |
| W | 0.115 | 0.135 | | 0.122 | 0.125 | 0.125 | 0.131 | | |
| X | 0.307 | 0.312 | | 0.311 | 0.312 | 0.311 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.360 | 0.360 | 0.360 | 0.360 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.624 | 0.625 | 0.626 | 0.629 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.243 | 0.246 | 0.247 | 0.248 | | |
| AE | 1.375 | 1.395 | | 1.381 | 1.387 | 1.386 | 1.387 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.247 | 0.248 | 0.247 | 0.251 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.000 | 2.000 | 2.000 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |

Accept/Reject

Measured by: EO 19ml
Date: 07/05/27

Audited by: JL
Date: 07/05/27

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | JL |

| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 31648 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

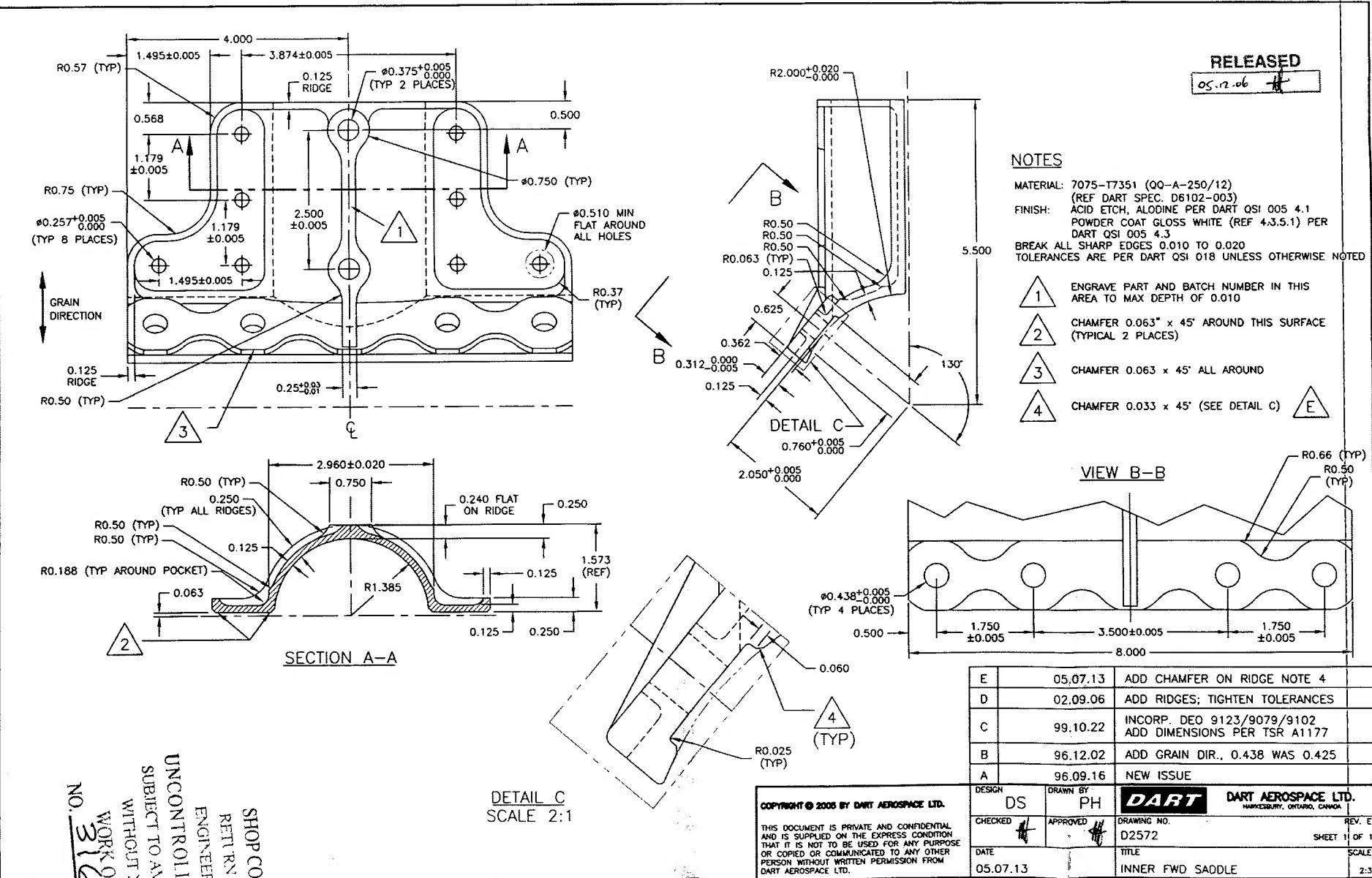
| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.439 | 0.439 | 0.439 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.000 | 8.000 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | 0.501 | 0.503 | 0.502 | 0.502 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.258 | 0.258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8684 | 0.376 | 0.376 | 0.376 | 0.376 | | |
| I | 0.490 | 0.510 | | 0.502 | 0.502 | 0.504 | 0.504 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.569 | 0.570 | 0.573 | 0.573 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| M | 1.490 | 1.500 | | 1.493 | 1.493 | 1.494 | 1.494 | | |
| N | 2.495 | 2.505 | | 2.498 | 2.499 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.871 | 3.871 | 3.871 | 3.871 | | |
| P | 0.115 | 0.135 | | 0.125 | 0.126 | 0.127 | 0.127 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.250 | 0.251 | 0.251 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.121 | 0.124 | 0.127 | 0.126 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.242 | 0.241 | 0.241 | 0.241 | | |
| W | 0.115 | 0.135 | | 0.130 | 0.126 | 0.128 | 0.129 | | |
| X | 0.307 | 0.312 | | 0.311 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.761 | | |
| Z | 0.352 | 0.372 | | 0.361 | 0.354 | 0.353 | 0.357 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.506 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.630 | 0.636 | 0.630 | 0.631 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.241 | 0.251 | 0.249 | 0.249 | | |
| AE | 1.375 | 1.395 | | 1.386 | 1.387 | 1.387 | 1.387 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.240 | 0.245 | 0.245 | 0.245 | | |
| AH | 0.240 | 0.260 | | 0.250 | 0.251 | 0.249 | 0.249 | | |
| AI | 2.000 | 2.020 | | 2.002 | 2.003 | 2.004 | 2.003 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|------------|-------------|-----------|
| Measured by: | <i>cmk</i> | Audited by: | <i>JL</i> |
| Date: | 07/05/27 | Date: | 07/05/27 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|-----------------------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM <i>JK</i> <i>JLM</i> | |

RELEASED

05.12.06



NO. 31648
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY